

Date: Thursday, 12/15/2005 3:55:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 25252	
Estimate Number : 10710	
P.O. Number : N/A	Part Number : D32111
This Issue : 12/15/2005 S.O. No. : N/A	Drawing Number : D3211 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/5/2006
Checked & Approved By : <u>SEE COMMENT BELOW</u>	Qty: <u>12</u> Um: Each
Comment : Est Rev:A New Issue 05-11-17 JLM	<u>11</u>

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4753 sf(s)/Unit Total: 14.7525 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Identify as D3211-1
 Batch: M19059

SA 05.12.21

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 17.800" x 11.375" (+0.000/-0.010)
 Grain along 11.375"

SA 05.12.21

12
X2

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3211-1 as per Folio FA348 and Dwg D3211
 Stack of 4

J.L 06.01.09 12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.01.09 12

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06.01.09 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:55:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25252

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

DL 06/01/13 12

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 06/01/14 11

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/01/18 11

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C2 06/01/24 12

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 01 21

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 76

C2 06/01/24 11

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAD 06/01/26 11 19 06/01/25

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-18	10	make change as shown permanent change				U 06-01-18	2 06-01-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/18
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/16	7	1 was scrap bend wrong way	18 06/01/16	Scrap + destroy	SB 06/01/16	2 06-01-16	2 06/01/16	2 06-01-16

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
A		A		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
		D3211		SHEET 1 OF 2	
DATE		TITLE		SCALE	
03.09.03		BRACKET		1:3	
A	03.09.03	NEW ISSUE			
A1	03.12.05	CHANGE ALL BEND RADIUS TO R0.125			

RELEASED
03.09.15

D3211-1 BRACKET

MACHINE PER DRAWING FILE "D3211-A2.DWG"

CHECK PER TEMPLATE D3211-1T1

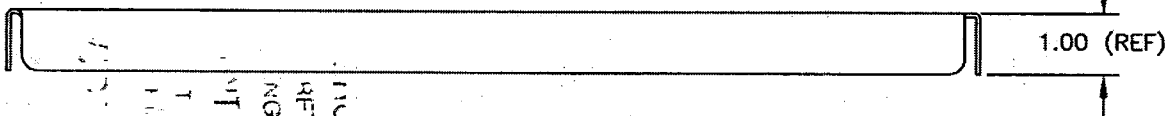
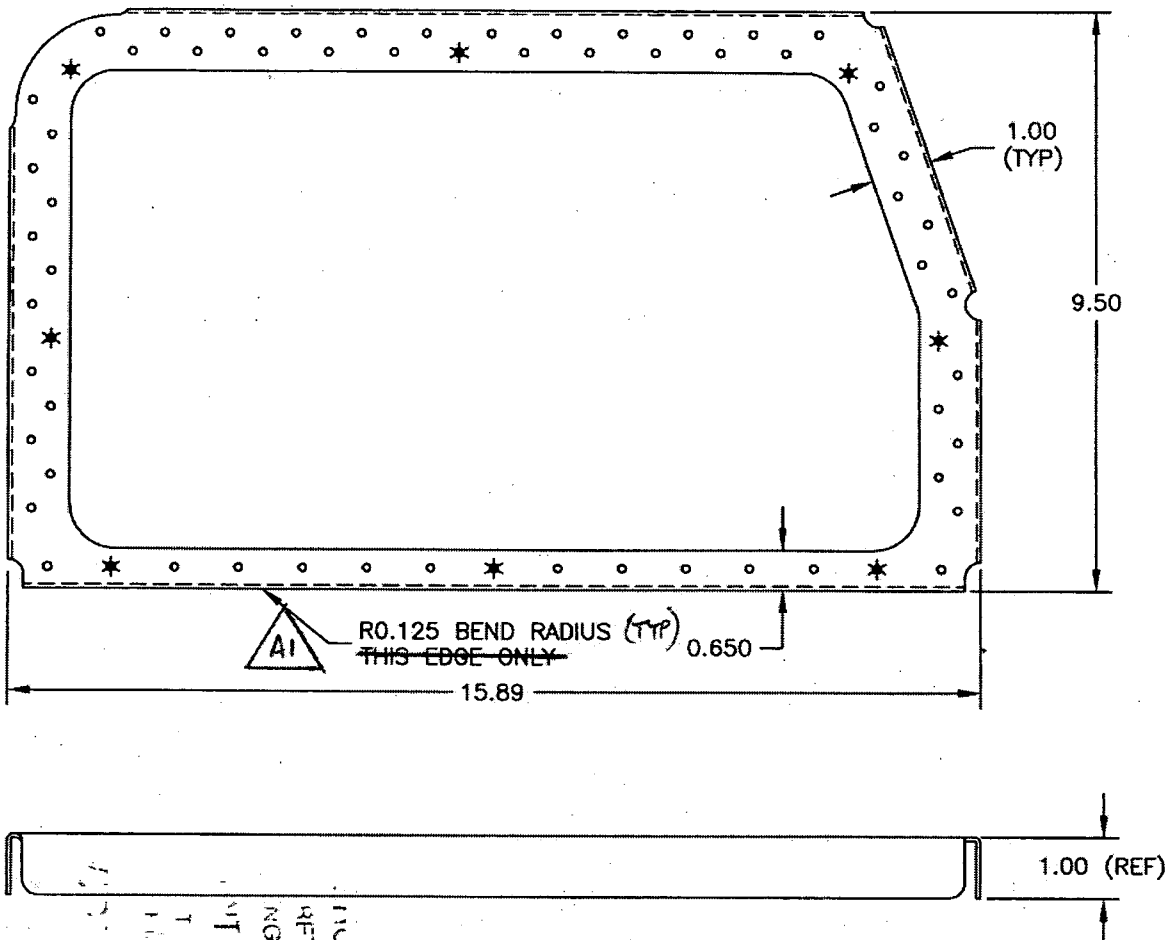
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

USE MINIMUM BEND RADIUS OF ~~0.188"~~ **0.125"** EXCEPT WHERE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



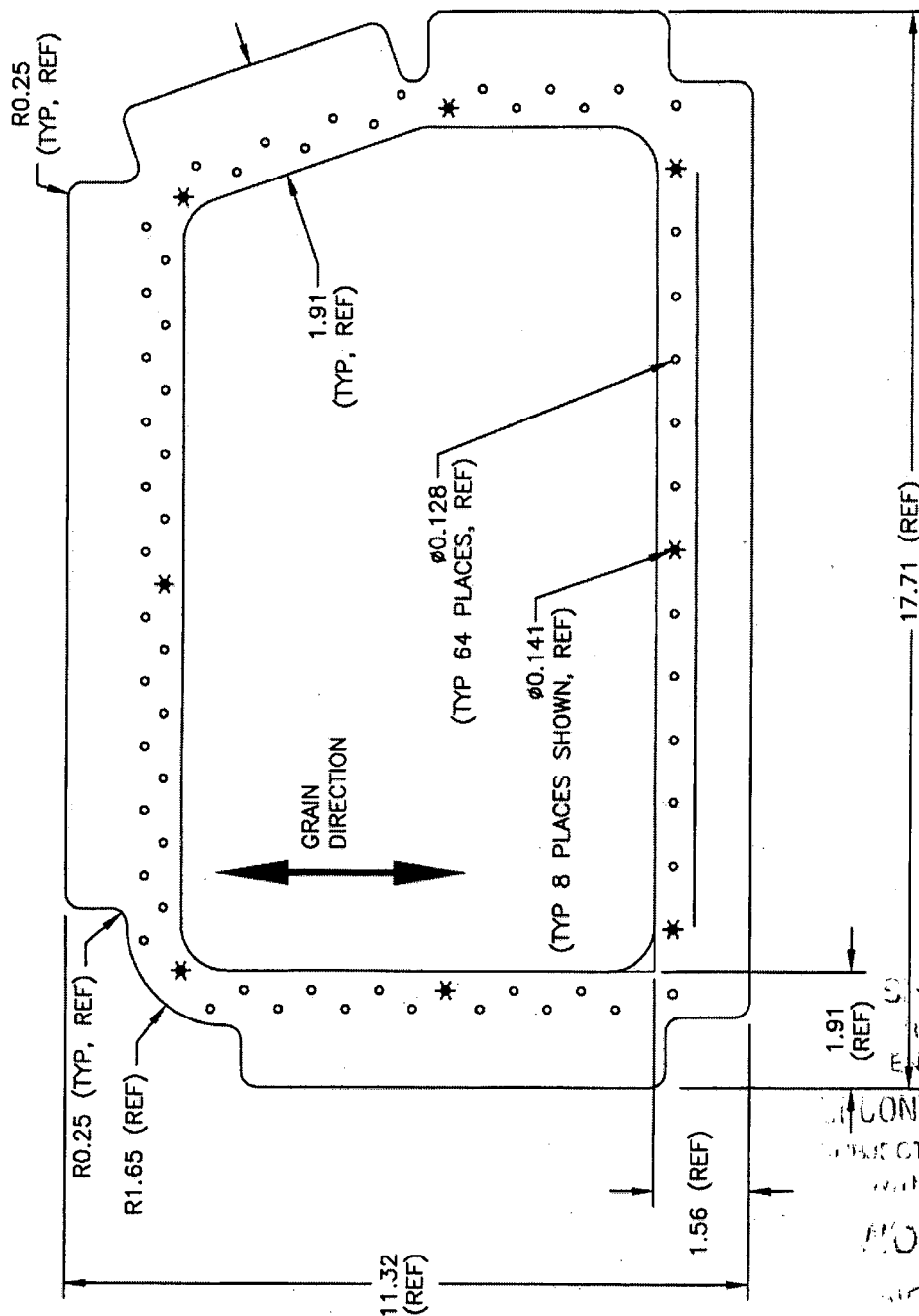
25252

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03.09.15

D3211-1 FLAT PATTERN

STOP COPY
RETURN TO
ENGINEERING

CONTROL

SUBJECT TO

DATE

11/01

25252

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